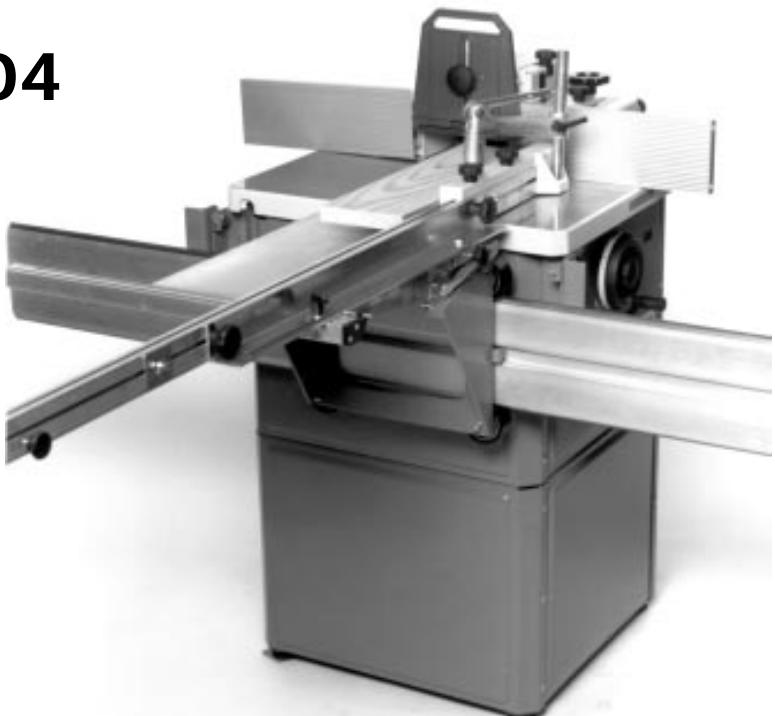




Ein Unternehmen der Metabo-Gruppe

- D Montage- und Betriebsanleitung Schiebeschlitten**
- ENG Assembly and Operation Manual
Sliding Carriage**
- F Instructions de service relatives au chariot coulissant**
- NL Montage en gebruiksaanwijzing Afkortgeleider**
- IT Istruzioni per l'uso ed il montaggio della slitta di spinta**
- ES Instrucciones de montaje y uso - Carro deslizante**
- DA Betjeningsvejledning Tapslæde**

TF 900/TF 904



D	Achtung!	Lesen Sie diese Anleitung vor der Installation und Inbetriebnahme aufmerksam durch.
ENG	Attention!	Carefully read through these instructions prior to installation and commissioning.
F	Attention!	Prière de lire attentivement la présente notice avant l'installation et la mise en service.
NL	Attentie!	Lees deze instructies voor de installatie en ingebruikname aandachtig door.
IT	Attenzione!	Prima dell'installazione e della messa in esercizio, leggete attentamente e completamente queste istruzioni.
ES	Atención!	Lea atentamente estas instrucciones antes de la instalación y puesta en marcha.
DA	Bemærk!	Læs denne vejledning opmærksomt igennem inden installationen og idrifttagningen.



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1 Scope of Application

This Sliding Carriage is intended for use with the Elektra Beckum Spindle Moulder models TF900/TF904. It is used for working across the endgrain of timber having a square or rectangular cross-section.

- Please observe all relevant safety regulations for the use of spindle moulders applicable in your area.

When in industrial use in the U.K. use of this accessory falls under the 1974 Woodworking Regulations. In the interest of health & safety of the machine user we recommend you study and follow these regulations.

We would also draw your attention to the booklet "Woodworking Machines Regulations 1974-Guidance on Regulations" ref. L4 /ISBN 0118855921) published by HSMO.

2 Specifications

Table size:	280 x 525 mm
Carriage travel:	700 mm
Fence:	adjustable 45° through 90°
Graduation:	1°
Carriage guides:	4 rollers, on ball bearings
Max. allowable workpiece weight:	20 kg
Mounting:	quick-action locks
Workpiece clamping:	quick-action clamp

3 Product Liability/Warranty

This product carries a 12 month manufacturer warranty under the prevailing legal provisions, which may vary from country to country. The warranty period begins with the date of the original purchase by the end user. Proof of purchase should be retained and must be presented in the event of a warranty claim. This warranty excludes and does not cover defects, malfunctions and failures caused by natural wear, overload, unreasonable use or failure to provide reasonable and necessary maintenance.

In case of a defect notify your dealer or Elektra Beckum distributor, who will decide how to handle your claim. Warranty claims can only be taken care of by your Elektra Beckum dealer or authorized service centre.

This product or any of its parts should not be altered or changed from standard specifications. The user of this product shall have the sole responsibility for any malfunction which results from improper use or unauthorized modification from standard specifications, faulty maintenance, damage or improper repair by anyone other than qualified person approved by Elektra Beckum or its representatives.

4 Safety Instructions

Feeding the workpiece with a sliding carriage is considered semi-mechanical feed. The cutterheads and moulding tools used must be approved for mechanical feed. Always perform such moulding operation with the cutterhead running at counterrotation, i.e. the cutterhead is turning against the direction of feed of the workpiece. Always have the workpiece firmly secured to the sliding carriage's table with the clamps provided.

5 Installation



Fit the two crosshead plates (370/371) to the machine housing.

Use 4 each
cup square neck bolt M 6x20
flange nut M 6



Hook roller carriage extrusion (358) with both extrusion brackets (319 + 320) onto the crosshead plates. If it is a tight fit remove some paint from the slots in the extrusion brackets.

Secure roller carriage extrusion by fixing the rear extrusion bracket (319) to the crosshead plate (371), to prevent unhooking.

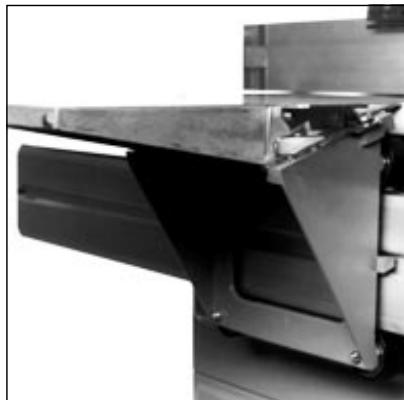
Use 1 each
hexagon head bolt M 6x16
hexagon nut M 6



Remove the front backstop plate (360) and slide traversing saddle onto the roller carriage extrusion.



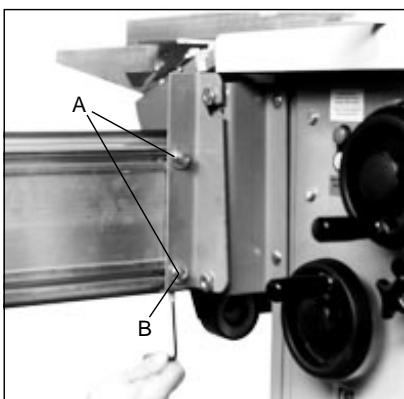
Reinstall backstop plate.



Place sliding carriage table onto traversing saddle and secure with the lock levers.
Loosely fit two cup square neck screws M 6x20 with washer Ø6.4, spring washer Ø6 and hexagon nut M6 to the two holes in the front of the carriage table.



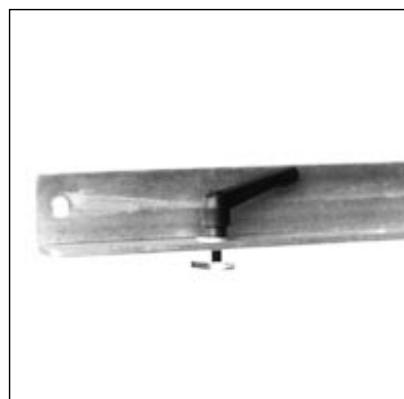
Slide link bracket extrusion on the heads of the just fitted cup square neck screws. At this stage do not tighten the screws.



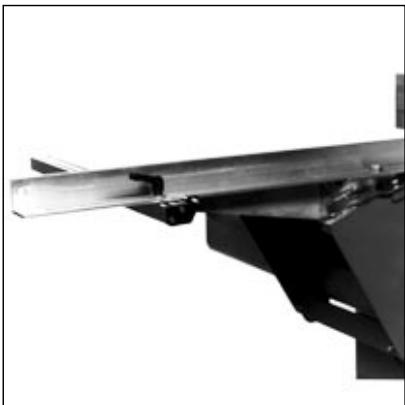
The carriage table should be set approx. 0.5 mm higher than the machine table. Set with setting screws B. Loosen screw holding rear extrusion bracket (319/371 and 320/370) to bracket before turning setting screw B and tighten after setting. Make trial cut to verify proper setting. After setting is completed, tighten all 4 nuts (408) M8 (A).



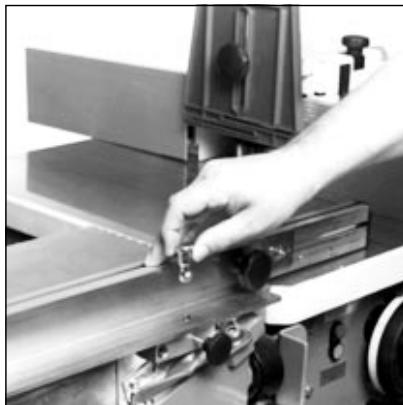
Alignment:
Set roller carriage extrusion parallel to the machine table with both front and rear setting screws C. It does not matter if the carriage table is higher or lower than the machine table.
After successful parallel alignment tighten the counter nuts on all 4 setting screws B.



Den Klemmhebel mit Unterlegscheibe durch den Schlitz der Kulissenschiene führen und den Stellgleiter aufschrauben.



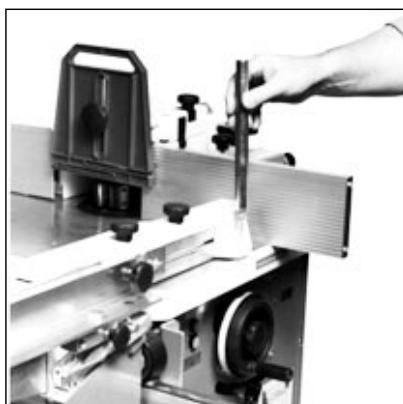
Fit slide washer into the groove of the link bracket extrusion. Insert pivot bolt and secure with starknob screw.



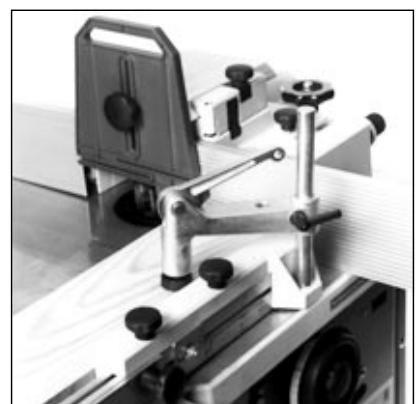
Put cup square neck screws M 6x20 into the slot of the fence extrusion and install the first stop plate with a nyloc nut M 6. Bolt fence extrusion to link bracket angle bar with 2 each cup square neck screws M 6x29, washers Ø 6 mm and 6 mm starknobs. Install second stop plate.



Attach link bracket extrusion end plate (357) with two pan head tapping screws to the link bracket extrusion. Set fence square with the machine's fence and set the link bracket extrusion to the zero mark by moving it as required.
- Exact setting is done with the setting screw.

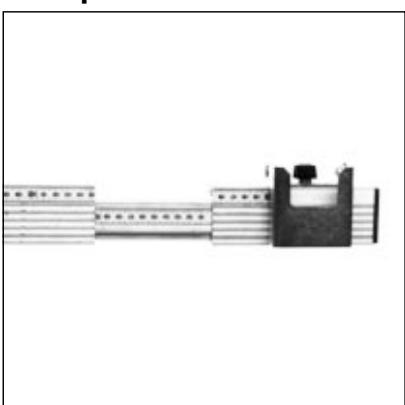


Install support rod (375) to clamping plate with hexagon nut M 12. Fit clamping plate to the fence extrusion end.
Hardware:
2 ea. hexagon head screw M 6x35
2 ea. washer Ø 6
2 ea. starknob M 6 female.



Place clamping arm, with spring fitted in groove, onto support rod and tighten ratchet lever to hold in position.
Short work is held on the clamping plate attached to the fence.

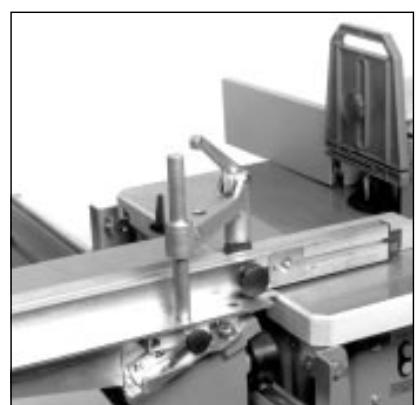
6 Operation



To work long stock the fence can be extended. Move the flipstop to the fence extension extrusion before extending the fence.



The pivot bolt is replaced by the clamping arm support provided, which is locked in position with the starknob screw.



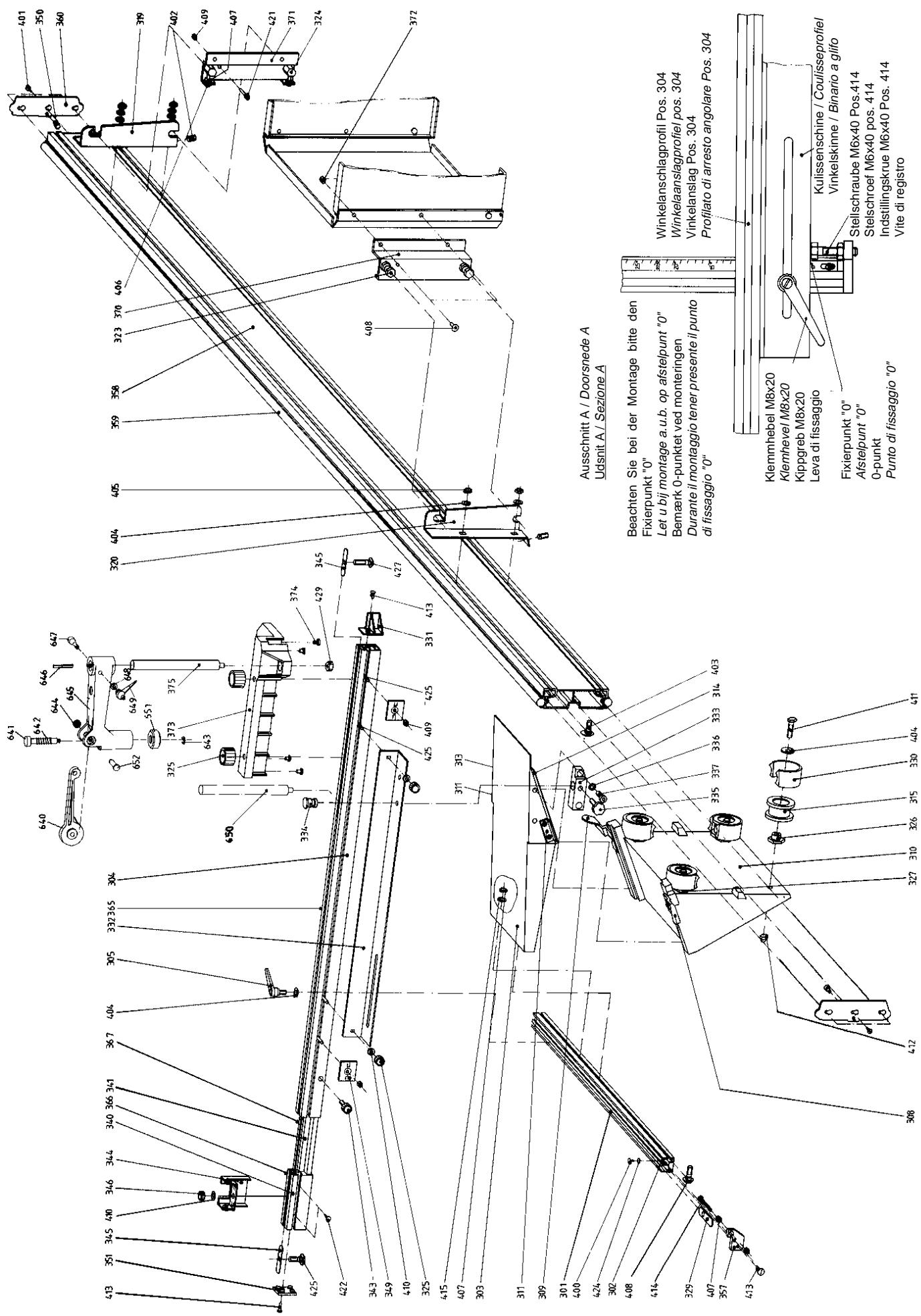
After removal of the clamping plate long workpieces are placed directly on the sliding table and held with the clamping arm mounted as shown at right.

7 Care and Maintenance

Regularly apply a light coat of oil to the guide bars. All grooves in the aluminium extrusions should be kept greased. The deep grooved roller bearing of the traversing saddle are factory lubricated for life and require no maintenance.

8 Spare Parts List Sliding Carriage TF 900/TF 904

Pos.	Description	Size mm	Stock-no.	Pos.	Description	Size mm	Stock-no.
301	Link bracket extrusion	600	139 320 1394	372	Flange nut	M 6	620 911 4230
302	Angle scale	553	114 220 1247	373	Clamping plate		138 011 0381
303	Planing bed	287x525	139 020 6760	374	Glide piece		239 120 2772
304	Fence extrusion	1410	139 320 4296	375	Support rod		148 211 0521
305	Ratchet lever	M 8x20	700 6043 407	380	Starknob screw	M 8x28	700 101 7777
308	Lock lever, right		149 201 9425	400	Pan head tapping screw	St 2.9x9.5	617 203 9632
309	Lock lever, left		149 201 9433	401	Pan head tapping screw	St 4.8x16	617 200 1830
310	Traversing saddle		139 020 1237	402	Hex. socket set screw, flat point	M 8x20	616 102 9309
311	Setting bracket		139 201 7573	403	Cup square neck screw	M 8x20	611 001 7942
313	Guide rail, left		149 201 9794	404	Washer	Ø 8.4	630 500 2486
314	Guide rail, right		149 201 9719	405	Hexagon nyloc nut	M 8	620 200 2305
315	Roller, c/w bearing	Ø 65x28	201 020 0140	406	Hexagon head screw	M 6x35	610 300 4916
319	Extrusion bracket, rear		139 220 1315	407	Hexagon nut	M 6	620 000 2219
320	Extrusion bracket, front		139 220 1307	408	Cup square neck screw	M 6x20	611 000 0608
323	Double collar nut	SW 19x40	139 520 1286	409	Hexagon nyloc nut	M 6	620 200 2291
324	Setting bolt	SW 19x34	139 520 1448	410	Washer	Ø 6.4	630 001 6365
325	Starknob	M 6	700 002 5458	411	Hexagon head screw	M 8x45	610 200 1085
326	Cam bush, lower	SW 30x25	139 520 1278	412	Cap nut, self-locking	M 8	620 807 3395
327	Roller bush, upper	Ø 30x25	139 520 1260	413	Countersunk head screw	St 4.8x22	617 406 3948
329	Sliding washer M 8	Fl 16x5x60	149 202 4500	414	Hexagon head screw	M 6x40	610 3001 151
330	PVC roller cover		239 120 1377	415	Split washer	B 6	630 100 0276
331	Fence end plate		239 120 1628	421	Hexagon head screw	M 6x16	610 301 5675
332	Link bracket angle bar	740	148 540 0792	422	Cross rec. head drilling screw	Ø 3.5x13	614 402 7270
333	Clamp bracket	25x25x100	148 240 0821	424	Washer	Ø 3.2	630 505 2335
334	Pivot bolt	Ø 20x35	148 540 0830	425	Cup square neck screw	M 6x16	611 000 0594
335	Starknob screw	M 6x16	700 105 9887	427	Cup square neck screw	M 6x35	611 002 9436
336	Serrated lock washer	Ø 6.4	630 408 4047	428	Hexagon socket head cap screw	M 6x16	612 705 9193
340	Fence extension	140	139 320 1645	429	Hexagon nut	M 12	620 001 7992
341	Fence extension extrusion	1520	139 320 1610	430	Washer	A 13	630 001 6705
343	Starknob screw	M 6x16	700 105 9887	640	Lock lever		138 040 0819
344	Flipstop		201 020 0388	641	Lock bolt		148 540 0857
345	Flipstop guide plate	Bl 0.88x16x70	139 220 1587	642	Pressure spring		705 100 5770
346	Knurled nut, Meplag	M 6	624 2018 000	643	Circlip for shafts	6x0.7	640 007 1061
349	Stop plate	Bl. 2x52x44	149 2097 752	644	Starlock with cap	Ø 8	701 612 3379
350	Plug	Ø 14x14	239 1203 906	645	Clamping arm		138 040 0800
351	End plate, fence extension		239 120 3760	646	Tension spring	0.9x6x40.5	705 240 0877
357	End plate, link bracket extrusion		239 120 5801	647	Clamping arm bolt	Ø 12 M 6x45	148 540 3732
358	Roller carriage extrusion	1500	139 320 5900	648	Washer	A 6.4 galv.	630 001 6365
359	Guide bar 1500, round	Ø 20x1499	148 211 3253	649	Ratchet lever, female	M 6	700 607 2385
360	Backstop plate		139 220 5965	650	Clamping arm support	Ø 20x237	148 540 0849
365	Scale 1410	1410	114 220 4700	651	Clamping pad	Ø 35x14	705 740 0867
366	Scale 140	140	114 220 4718	652	Bolt	A 8x35	663 212 3360
367	Scale 1350	1350	114 220 4726				
370	Crosshead plate, right		138 210 0820				
371	Crosshead plate, left		138 210 0839				



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